

Date: Monday, 07/04/2008 2:29:12 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG		
Job Number	: 38441			Part Number	: D2591		
Estimate Number	: 10008			Drawing Number	: D2591 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/04/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: //	Type	: MACHINED PARTS	Due Date	: 24/04/2008		
Previous Run	: 37857			Qty:	<i>50</i>		
Written By	:			Um:	Each		
Checked & Approved By	: <u>JO 08.4.06</u>						
Comment	: Est Rev:I Removed from 9 Digit 05-10-25 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"	
		Comment: Qty.: 0.2340 f(s)/Unit Total : 5.6160 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: <u>1107573</u>	<i>On 08/04/08</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.700" long	<i>On 08/04/08</i>
3.0	<u>HAAS</u> <i>machining</i>	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 issue P10 per meter as per dwg D 2591 Rev. D. 2-Deburr if required	<i>R10' 6097</i>
4.0	Q02	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>Rec'd + inspect for transit damage</i>
5.0	Q06	SECOND CHECK	
		Comment: SECOND CHECK	<i>80/04/08 (X50) count</i>

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Description :

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT Dovel

AS 08/04/25 (55)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28 JJ

Job Completion



MF 08-04-25

DART AEROSPACE LTD	Work Order:	38441
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

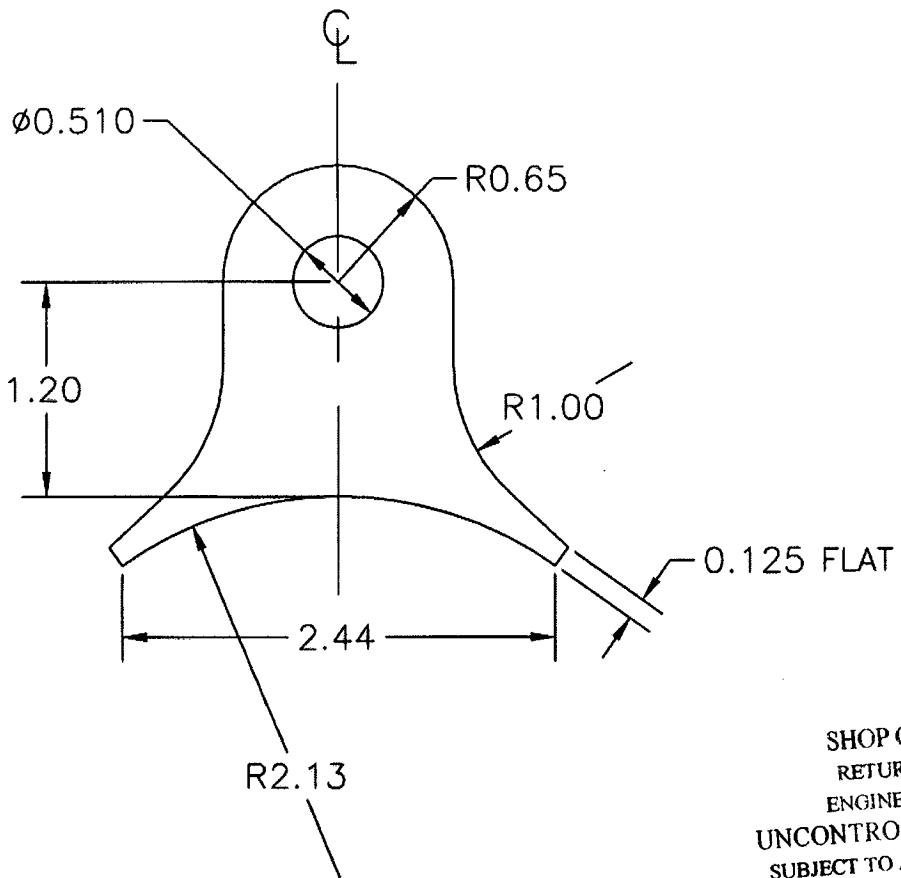
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DS1 9161-011	KJ/JLM	SJL

DART

DESIGN <i>DRWY</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED

48.01.21 DS



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 3844

00.04.05
 0.063

BREAK ALL SHARP CORNERS ~~0.010~~ TO ~~0.020~~

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2591	Lug in Steel	6097
		MATERIAL: supplied by DART M1010B0750X02500 M107513	
200	D2230-3	Mounting Lug	6097
		MATERIAL: supplied by DART D2423 B33310	

We hereby certify that the above parts were made in conformance with applicable drawings.

[Signature]
METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, April 24, 2008